

Work Order ID 157182 -2

157182

Page 1

Tuesday, February 21, 2017 7:43:22 AM

Item ID: D3197-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Bar

Stop *NS2*

Start Date: 2/8/2017 **Start Qty:** 4.00 2 *4*

Cust Item ID:

Required Date: 2/17/2017 **Req'd Qty:** 4.00 ***A***

Customer:

Reference:

Approvals: Process Plan: _____ Date: FEB 21 2017
QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run	Start	*NR1*
	Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3197 Rev B

100

0.00

100

BAND SAW

Bandsaw

Memo

Jeaspa Bandsaw

Cut blanks: 29.125" long

110

0.04

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

HAAS CNC vertical machine #1

1-Face ends to lenght per dwg D31972-Machine D3197-1 as per Folio FA340 and Dwg D31973-Deburr

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____						
Misidentified	☐	Past Due	☐							

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[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
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								Lead hand / Supervisor Approval Verification	
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Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Work Order ID 157182

Tuesday, February 21, 2017 7:43:22 AM

157182

Page 3

Item ID: D3197-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bar

Stop

NS2

Start Date: 2/8/2017

Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/17/2017

Req'd Qty: 4.00

4

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

NR1

NR2

Sequence ID/
Work Center ID

Operation

Description

Set Up/

Run Hours

Tool ID

Tool #

Plan

Code

Accept

Qty

Reject

Qty

Reject

Number

Insp.

Stamp

100

Grey Sandtex (Ref: 4.5.5.6) per QSI005 4.5

0.00

157182

Powdercoat

Memo

0.02

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

170

170

QC

Memo

0.01

Quality Control

MAR 23 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Work Order ID 157182

Thursday, April 13, 2017 7:47:08 AM

157182

Page 3

Item ID: D3197-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bar
Start Date: 2/8/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 2/17/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: _____ OVEN TEMPERATURE: FINISH TIME: _____	0.00 0.42							
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.04							
180 *180* Small Fab Small Fab Small Fab	Small Fab Memo Assemble D3197-041 as per Dwg D3197	0.00 0.67							

See page before

DAS
30
9-89

2 *ff* APR 13 2017

Work Order ID 157182

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157182

Page 4

Item ID: D3197-041 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Bar
 Start Date: 2/8/2017 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 2/17/2017 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				2			DAS 38 9-88 APR 17 2017
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <u>51256</u> Memo	0.00 0.01				2			MAY 16 2017 APR 10 2017 DAS 6 9-88
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.07							DAS 21 9-88 MAY 17 2017 W 17.05.17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Picklist Print

Tuesday, February 21, 2017 7:43:26 AM

Page 1

Work Order ID: 157182

157182

Parent Item: D3197-041

D3197-041

Parent Item Name: Bar

Start Date: 2/8/2017

Required Date: 2/17/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev: A New Issue 05-11-08 JLM
IPP Rev: B As per Rev B 06-03-10 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MS27039-1-24		Purchased	No			100	Each	76.0000	2	8			
										**	FF	MAR 23 2017	
MS27039-1-24													
Screw													

Location Loc Qty Loc Code

ST279 76

m134537 76

D2690-5		Manufactured	No			180	Each	4.0000	2	8			
										**	FF	MAR 23 2017	
D2690-5													
Lanyard Assembly													

Location Loc Qty Loc Code

ST009 4

155597 4

D3242-1		Manufactured	No			180	Each	11.0000	2	8			
										**	FF	March 23-17	
D3242-1													
Tag													

Location Loc Qty Loc Code

GA 11

135074 2

152857 3

154878 6

D3489-3-200		Manufactured	No			180	Each	10.0000	2	8			
										**	FF	March 23-17	
D3489-3-200													
Pip Pin													

Location Loc Qty Loc Code

GA 157821 10

152735 8

154114 2

B 157 835

DAS
30
9-89

3

Picklist Print

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Tuesday, February 21, 2017 7:43:26 AM

Work Order ID: 157182

157182

Parent Item: D3197-041

D3197-041

Parent Item Name: Bar

Start Date: 2/8/2017

Required Date: 2/17/2017

Start Qty: 4.00

Required Qty: 4.00

M7075T73R1.000

Purchased

No

180

f

14.0160

2.42

12.1

M7075T73R1 000

7075-T73 Rd Bar 1.00

Location

Loc Qty

Loc Code

MAT

14.016

m134522

6.88

→ m136396 2

7.136

7.136

2,227.000

2

8

MS21042L3

2 M137041X S.1
Purchased No

MS21042L3

Nut

FF

MAR 7 3 2017

Location

Loc Qty

Loc Code

FP001

100

m135945

100

GA

318

m134360

108

m135135

18

M136665

192

OVER007

300

m134360

0

M136665

300

ST303

509

M136406

9

M136554

500

ST3030

1000

M136838

1000

Tuesday, February 21, 2017 7:43:26 AM

Shop Packet Print

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